

Order ID 71277

June 24, 2011 3:45:10 PM

SHIP July 6th



Page 1

Item ID: D3324-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 6/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

HP

Date: *11-06-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3324

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	<i>m112786</i>
4	D3324-3	Full Length Tube	<i>m112786</i>
2	D3324-5	Top End Tube	<i>m112786</i>
2	D3324-7	Bottom End Tube	<i>m112786</i>
10	D3324-9	Vertical Tube	<i>m112786</i>

M11-06-29

2- Weld as per dwg

AVR 4130 Rod : M1000TS

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

BE 11-07-04

1 0 BE 11/07/04

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 71277

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 407105

Quality Control

~~1-0 8/10/07/04~~

121

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IX 0 M-L 11/07/05

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Page 3

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Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

1ST COAT:

START TIME: 8:45

OVEN TEMPERATURE: 400.5

FINISH TIME: 9:15

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

0.00

IX ~~Ø~~ M-L 11/07/05

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

1 0 BL 11-7-5.

W/O:		WORK ORDER CHANGES					
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Page 4

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Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location:

G-A

0.00



Packaging

Memo

w/o 7127C

0.00

Packaging

EB 11/07/05 @

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/05

NF
11-07-05

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NOTE: Date & initial all entries

Friday, June 24, 2011 3:45:17 PM





Parent Item: D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 6/24/2011**Required Date:** 6/30/2011**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP Rev:A 05.02.09 New issue KJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3  Basket Hinge		Manufactured	No			100	Each	28.0000	2	2		11.06.29	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA005			28						
				33872			28						
D3348-1  Clevis		Manufactured	No			100	Each	13.0000	4	4		11.06.29	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA005			13						
				44246			13						
D3349-3  Spacer Bushing		Manufactured	No			100	Each	4.0000	2	2		11.06.29	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA005			4						
				41831			4						
D3367-1  Mounting Bracket		Manufactured	No			100	Each	28.0000	2	2		11.06.29	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA005			28						
				43228			28						

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, June 24, 2011 3:45:17 PM

Page 2

Work Order ID: 71277



Parent Item: D3324-041



Parent Item Name: Basket Base Assembly

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased No

100 f

414.3443

46.6

49.05263



SAD 11-06-27

4130 Square tube .500 x .500 x .035w

Location

Loc Qty

Loc Code

MAT034

414.3443

109127

216

109385

15.75

112786

182.5943

M569EX0.50-18F

Purchased No

100 sf

74.0000

28

28



49.0527

6/24/07-04

569 Expanded Metal

Location

Loc Qty

Loc Code

MAT018

74

112776

10

117806

64

28

Friday, June 24, 2011 3:45:17 PM

Shop Packet Print

Page 2

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DART

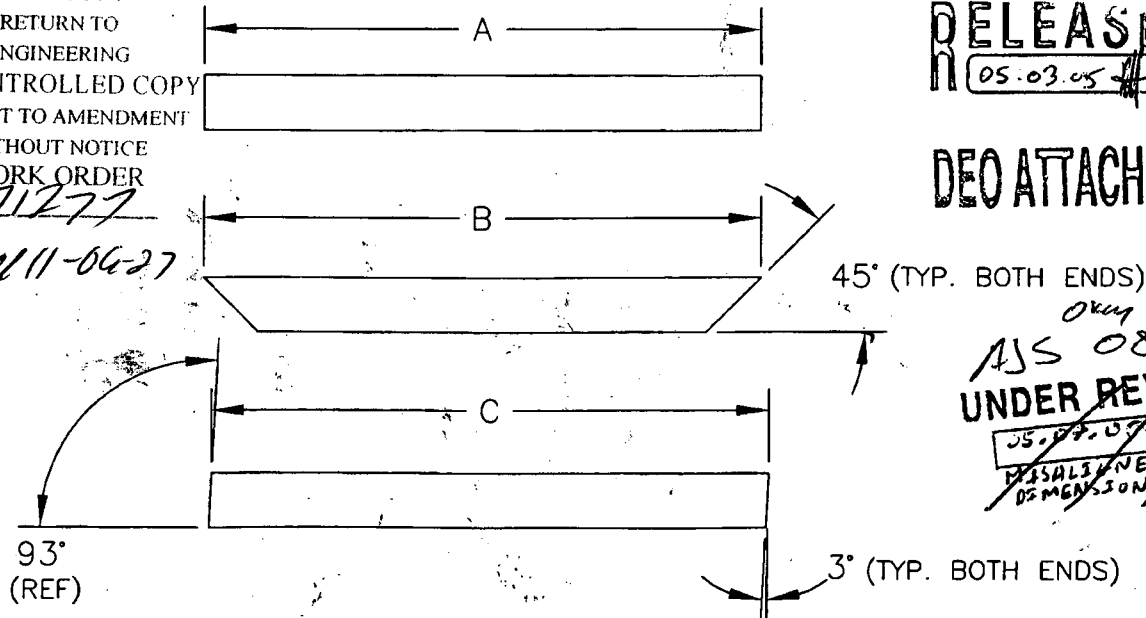
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *71277*

PL11-06-27



RELEASED
05.03.05

DEO ATTACHED

OKAY
ASS 08.12.15
UNDER REVIEW
05.04.05 PH
DESIGNED
DIMENSION P & A

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

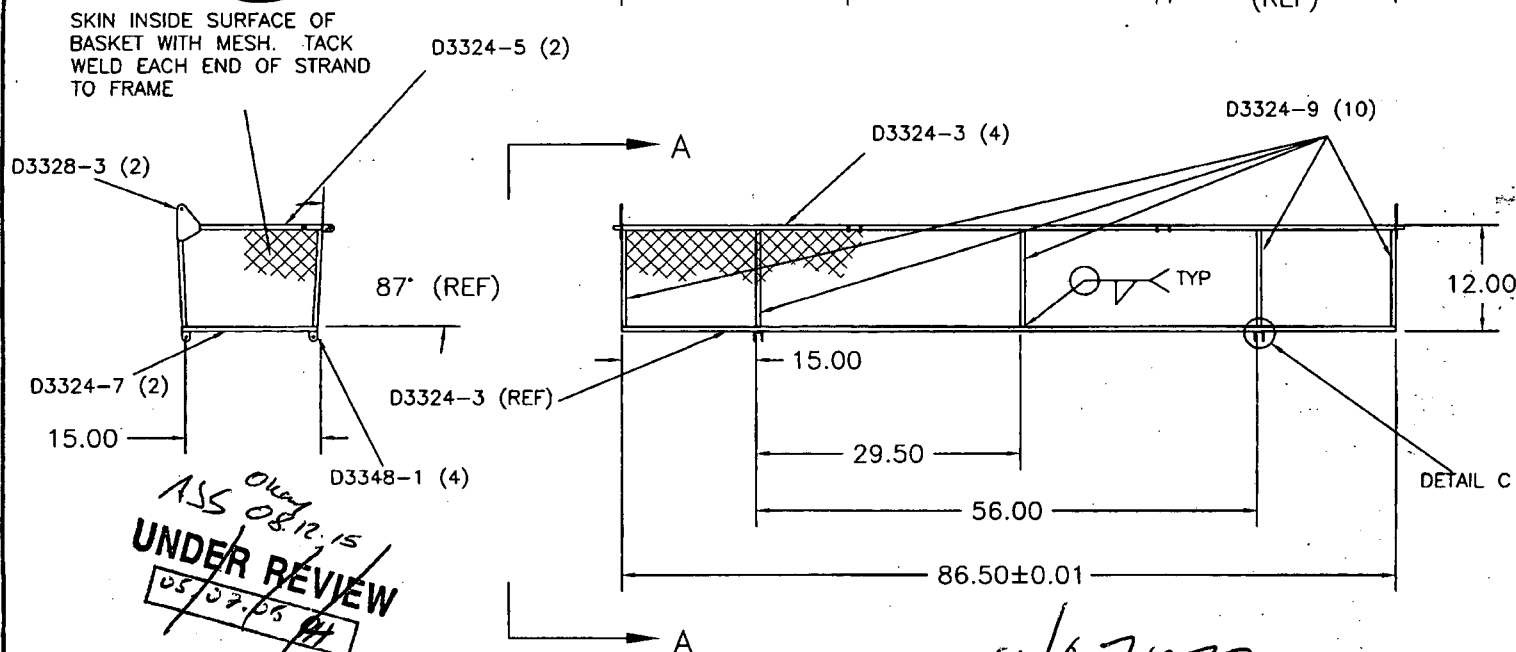
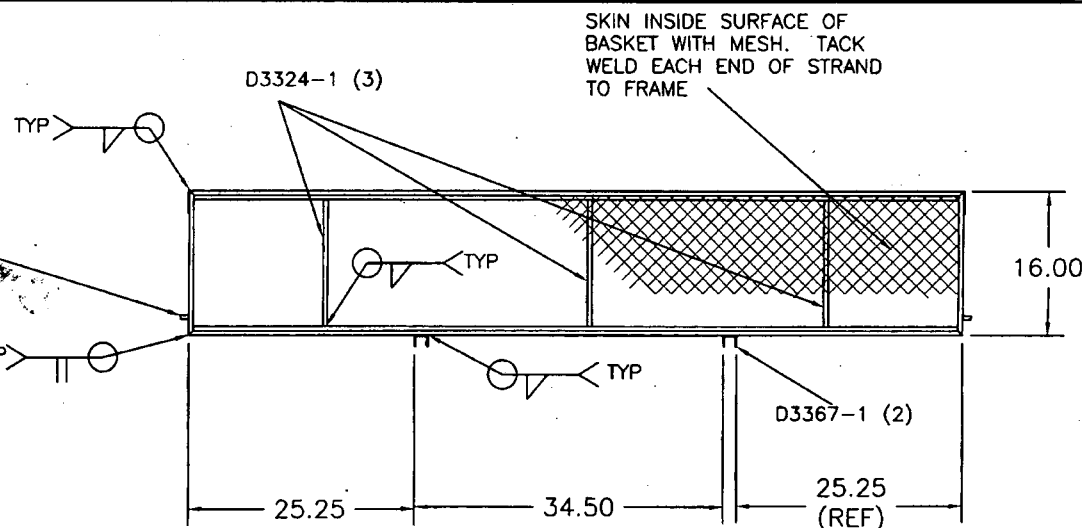
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DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.03.04	DRAWING NO.	D3324	REV. B
		TITLE	BASKET BASE ASSEMBLY	SHEET 2 OF 3
		SCALE	1:20	



D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

RELEASED
05.03.05

DEF ATTACHED

ASS OK'd 08.12.15
UNDER REVIEW
05.07.05

u/o 71277

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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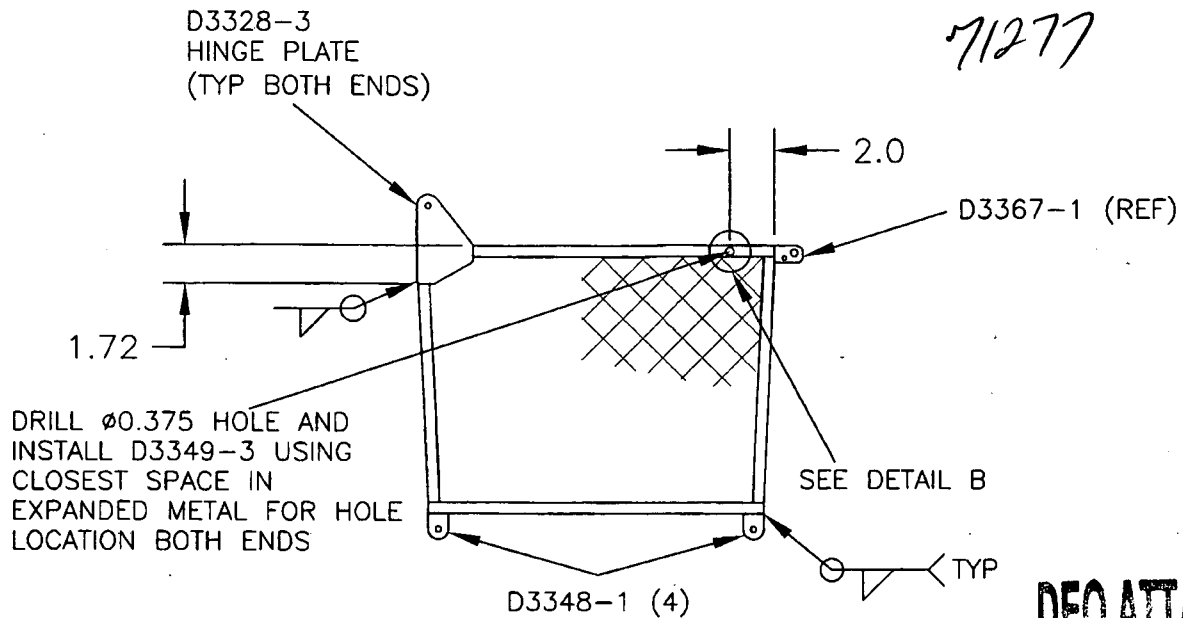
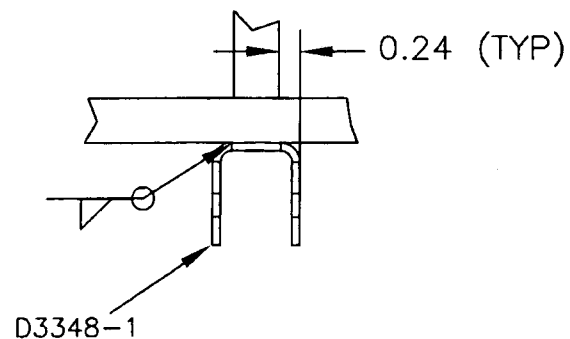
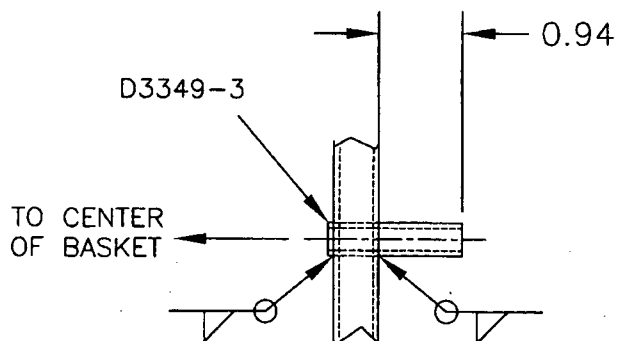
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DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8

**DEO ATTACHED****RELEASED**
05.03.05

OK
ASS 08.12.15
UNDER REVIEW
05.07.06

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

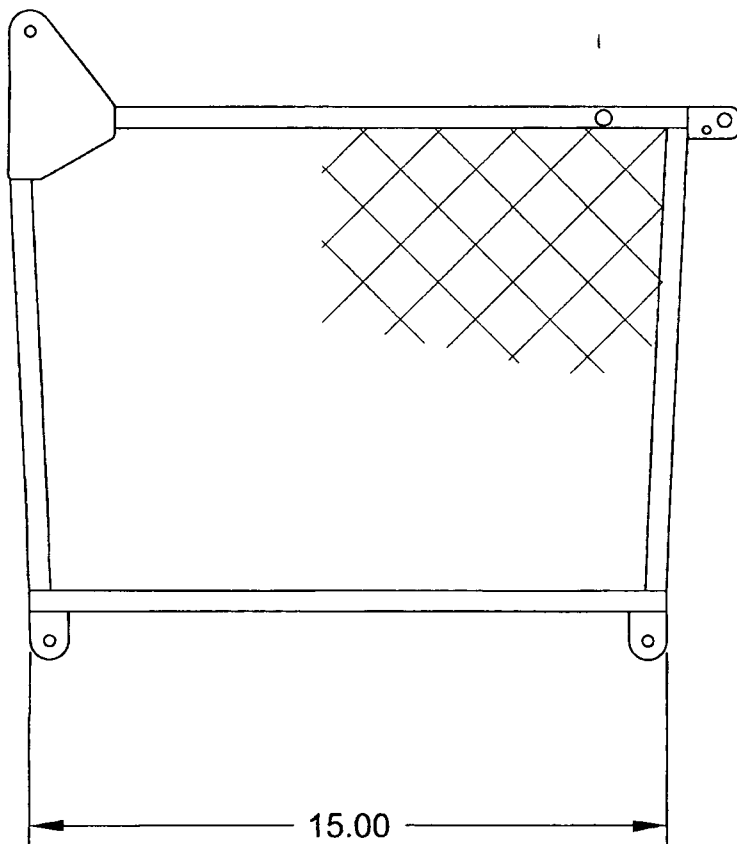
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DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.28	DATE 08.11.28	DATE 08/12/01	DATE 08/12/01		DATE 08.12.01		

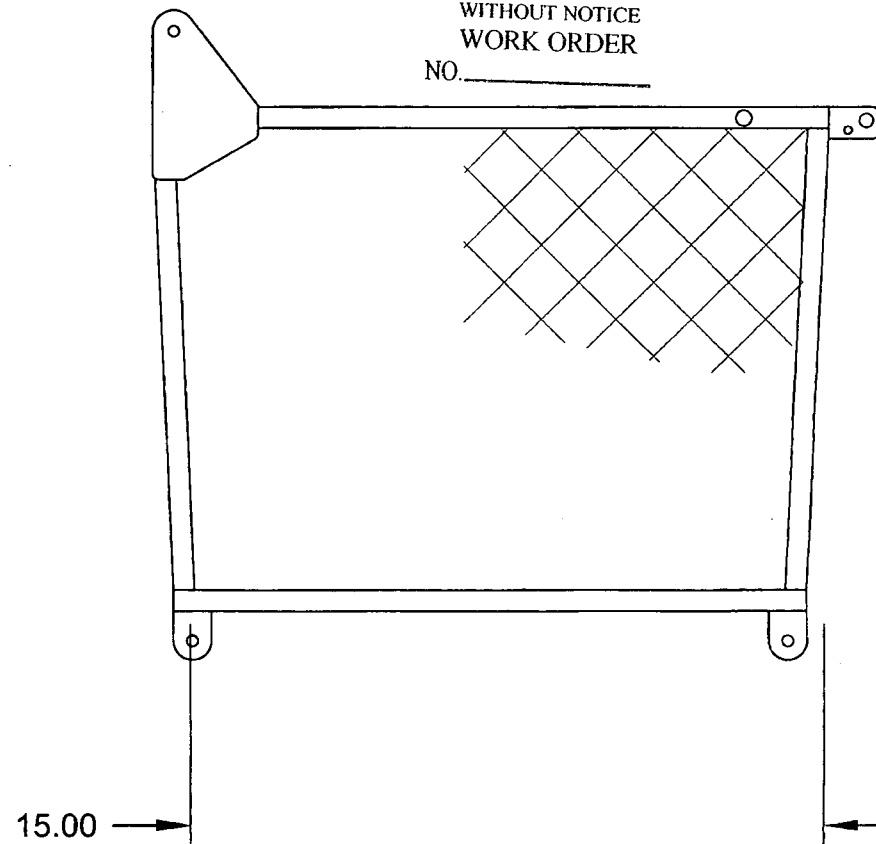
SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____



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